

Date: Wednesday, 2/20/2008 4:21:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOW PROFILE BASKET LID ASSY
 Job Number : 37528
 Estimate Number : 13153
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1 / Type : LARGE FAB ASSY
 Previous Run : 37527
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A new issue 08-01-30 DD verified by:EC

Part Number : D3713042
 Drawing Number : D3713 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 3/10/2008 Qty: 1 Um: Each

POSITIVE RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s)
 304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

| QTY | PART NUMBER | BATCH |
|-----|-------------|---------|
| 2 | D3714-1 | M107038 |
| 2 | D3715-1 | M107038 |
| 10 | D3716-1 | M107038 |
| 4 | D3732-1 | M107038 |

~~2327~~ ~~2327~~

2- Deburr

25 08/02/26

2.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing
 batch 336920

pl 08.02.27

3.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 batch B36481

pl 08.02.27

4.0 D37491 HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 HINGE HALF
 batch 337202

pl 08.02.27

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37528

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate

batch *335686*

Pl 08.02.27

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- drill holes in both D3715-1 as per dwg D3715 *08/02/26*

2- deburr *08/02/26*

3- assemble as per dwg D3713 and weld as per QSI004

Pl 08-02-27

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number Description Batch
17sq.ft M304EX0.75-16F Expanded Metal

08.02.27

Pl 08.02.27

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh as per dwg D3743

2- weld mesh as per dwg D3713

Pl 08.02.27
Pl 08.03.03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37528

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

ASS 08.03.10/508/08/10

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-07 ①

13.0

POWDER COATING

POWDER COATING



M100700



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FX 08/03/11 ①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08-03-11

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M106894



①

Comment: Wing Walk as per Dwg D3713 and QSI 005 4.4

FX 08-03-11

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 007-03-12 ①

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 08-03-12 ①

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/3/13 ①

POSITIVE RECALL

EFFECTIVE 08/02/11

AUTH 4

RELEASED

DATE

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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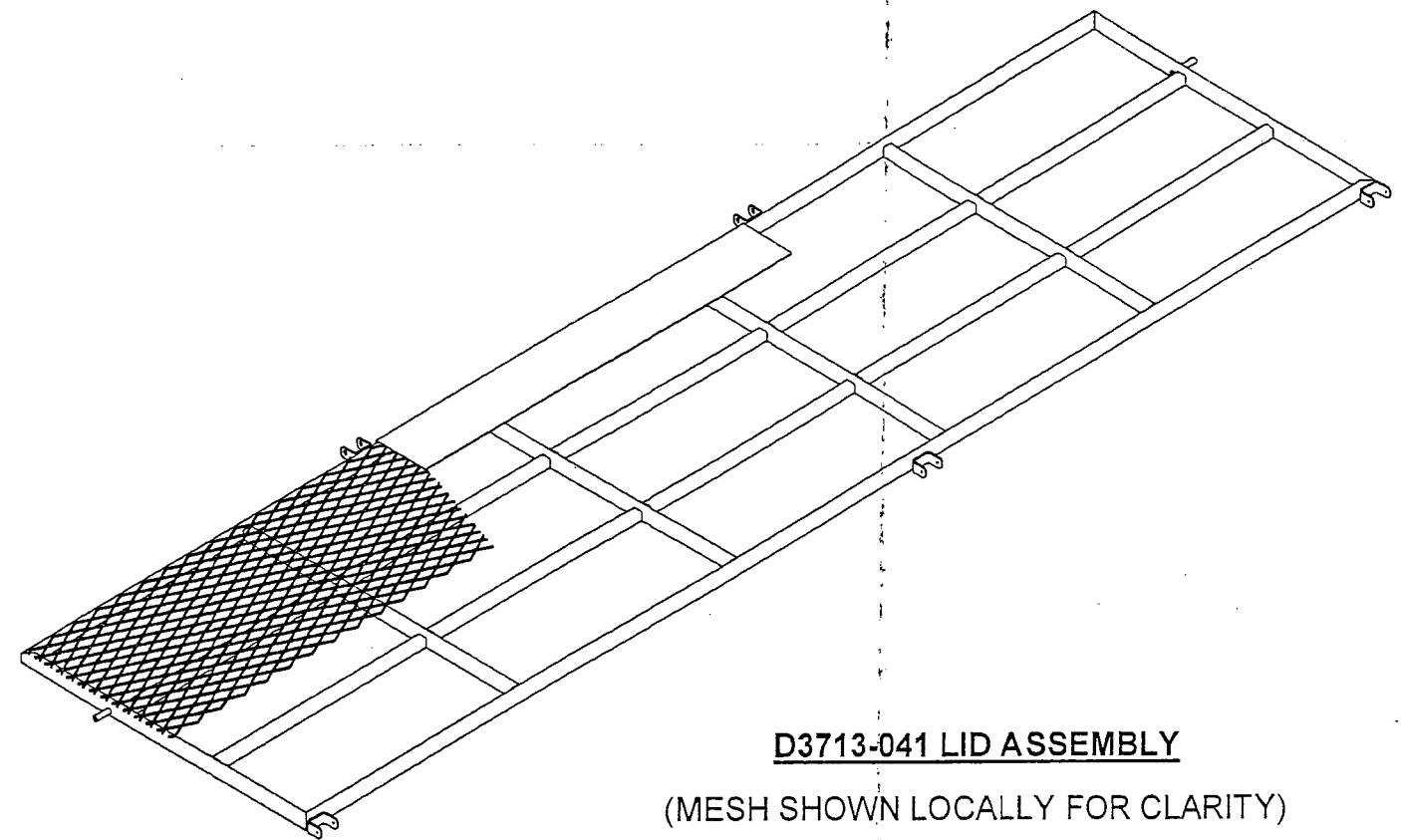
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| QTY. | PART NUMBER | DESCRIPTION |
|------|-------------|-----------------------------|
| X | D3713-041 | LID ASSY LOW PROFILE BASKET |
| 2 | D2327-1 | SPACER |
| 1 | D2329 | LABEL PLATE |
| 2 | D2581 | MOUNTING BRACKET |
| 2 | D3714-1 | RIB |
| 2 | D3715-1 | RIB |
| 10 | D3716-1 | RIB |
| 4 | D3732-1 | RIB |
| 1 | D3743-1 | MESH |
| 3 | D3749-1 | HINGE HALF |



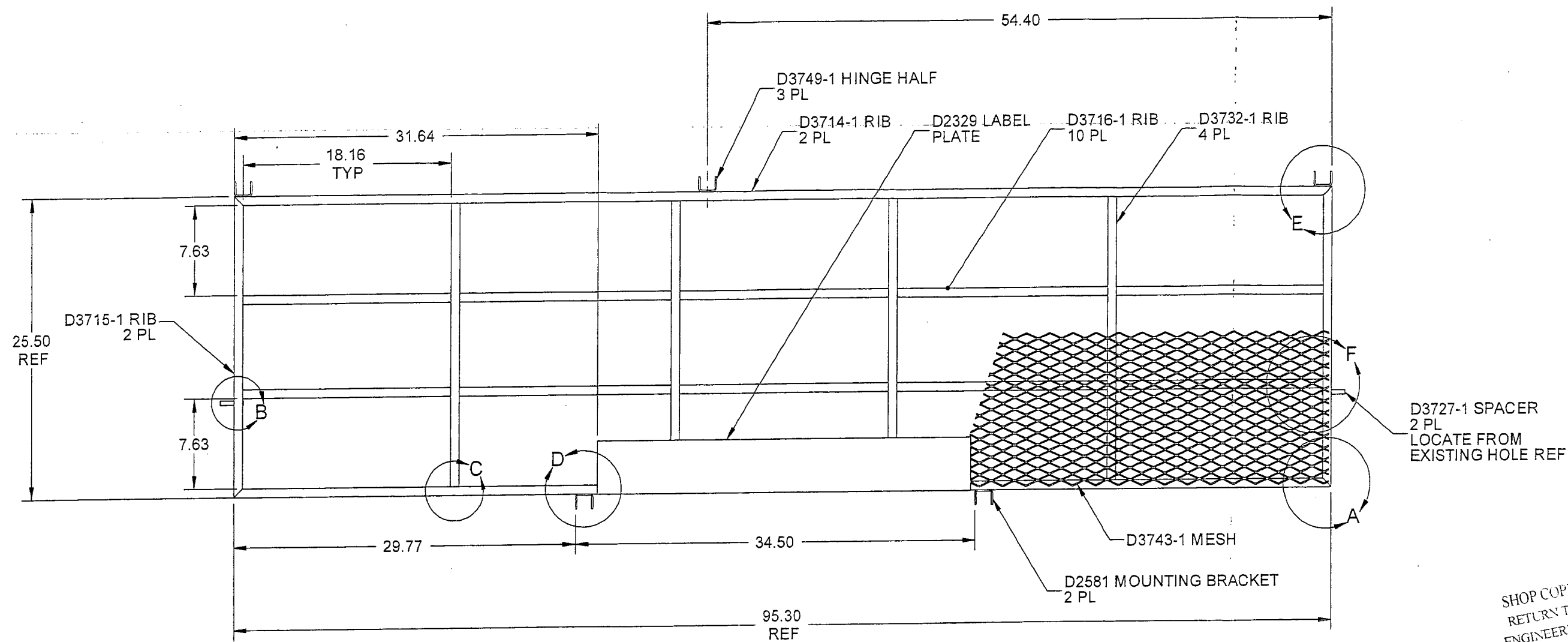
D3713-041 LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37528

PRELIMINARY ISSUE
UE 08.02.15

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 36 lbs APPROX.
 - 8) WELDING: PER DART QSI 004


| | | | |
|------------|-------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A | NEW ISSUE | AJS | 08.02.01 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. | REV. A |
| CHECKED | UE | D3713 | SHEET 1 OF 3 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | LID ASSEMBLY | NTS |
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| DATE | 08.02.01 | | |

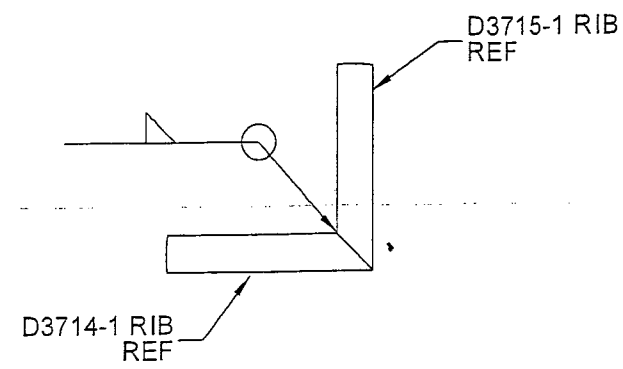


D3713-041 LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

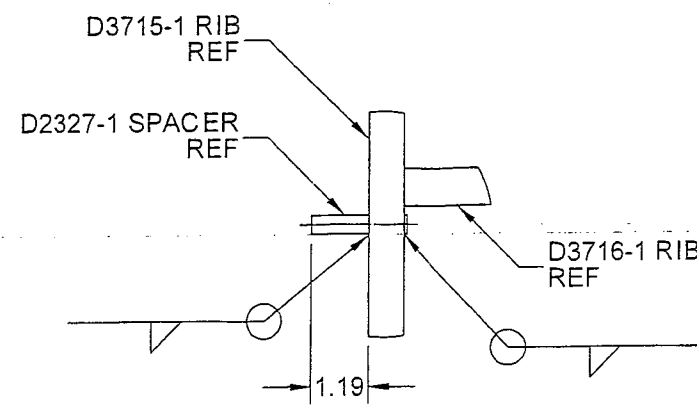
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PRELIMINARY ISSUE
08.02.15

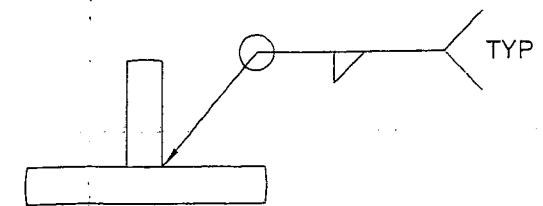
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| DRAWN | | | |
| CHECKED | LE | DRAWING NO. | REV. A |
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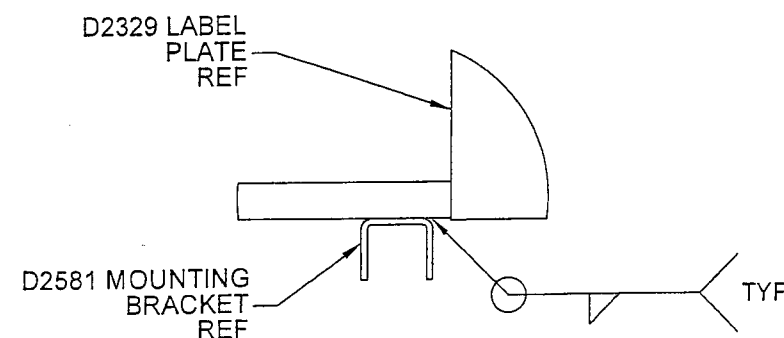
DETAIL A: TYP CORNER WELDS
SCALE 4X
(MESH NOT SHOWN FOR CLARITY)



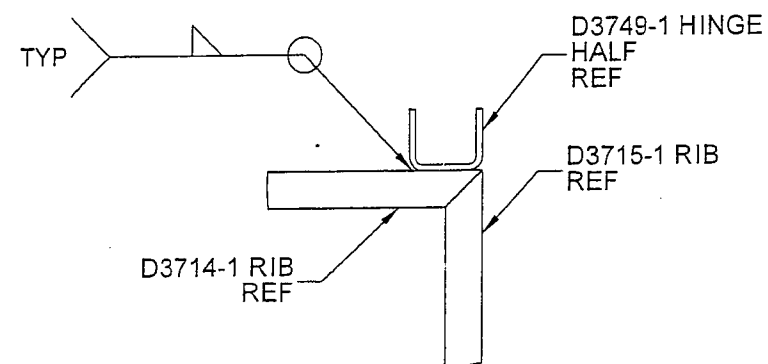
DETAIL B
TYP BOTH ENDS
SCALE 4X



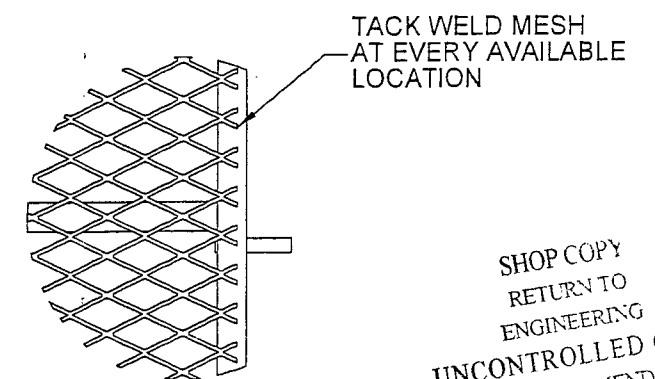
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X



DETAIL E
SCALE 4X



DETAIL F
SCALE 5X

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PRELIMINARY ISSUE
08.02.15

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| MFG. APPR. | | D3713 | SHEET 3 OF 3 |
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